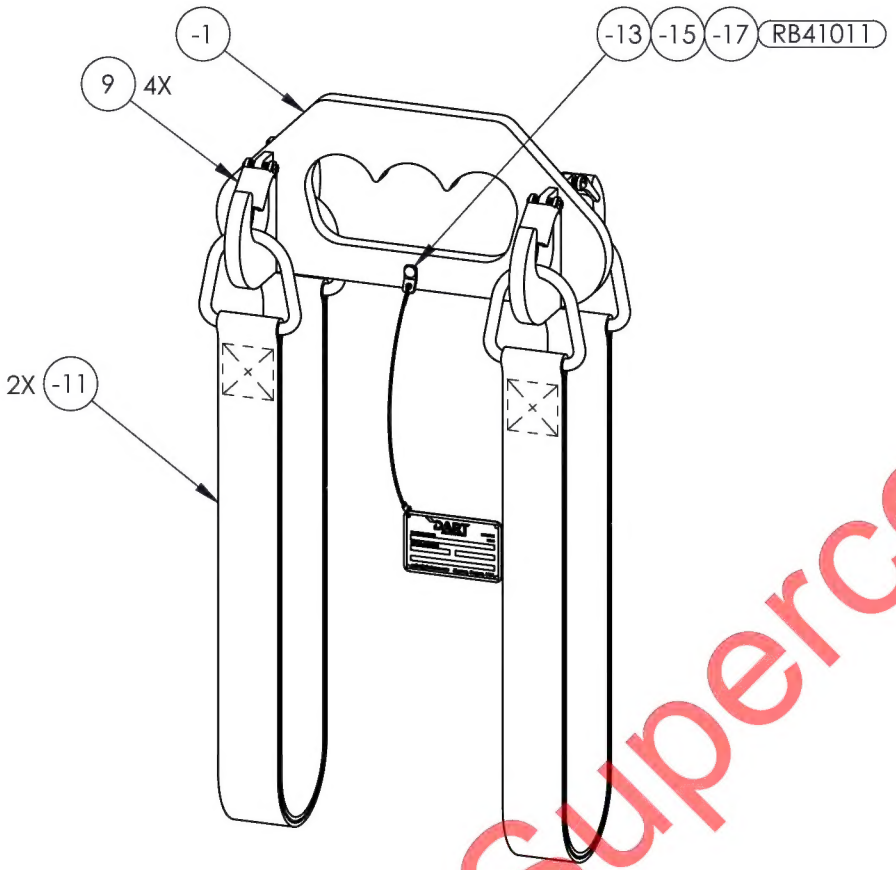
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION	7/13/2016	SM	JAG



DART AEROSPACE

CAGE CODE 3AL64

PART NUMBER RBE117-W3

SERIAL NUMBER - - - - - - - -

SWL 8,000 LBS.

WEIGHT TESTED 12,000 LBS. --/--/----

sales@dartaero.com Eugene, Oregon, USA

SEE ATTACHED DEVIATION

NOTES:
1. REF. EUROCOPTER T/N: 117 W3.
2. WEIGHT TEST TO A TOTAL 12,000 LBS. (6,000 LBS. PER SLING).

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	WELDMENT			2
	1		-3		FRAME	1018/1020 CR		3
	4		-5		HOOK	1018/1020 CR		4
	4	B/O	-7		SPRING PIN	STEEL	Ø1/4 x 1-1/8 (MCMASTER-CARR # 98296A927)	2
		B/O	9	4	SPRING LATCH W/ BOLT & NUT	S.S.	1-5/8 x 9/16 x 3/8 (MCMASTER-CARR # 3526T72)	1
		B/O	-11	2	BASKET SLING		2 PLY, 2 IN x 36 IN, 12,800 LB CAPACITY (MSC # 85810844)	1
		B/O	-13	1	LANYARD CABLE		Ø1/16 x 8in (CARR-LANE # CL-102-KA-9)	1
		B/O	-15	1	FERRULE	AL	2 x .60 (CARR-LANE # CL-4-F)	1
		B/O	-17	1	METAL SCREW NAIL	STEEL	#10 (MCMASTER-CARR # 90081A240)	1
		B/O		1	DART PLACARD	ALUMINUM	RB41011	1

DART AEROSPACE

TITLE: MAIN ROTORHEAD REMOVAL/INSTALLATION HOIST

DWG NO. RBE117-W3 REV 1

MAT'L

HEAT TREAT

FINISH

SPEC

DRAWN BY:	CLOUGH
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT

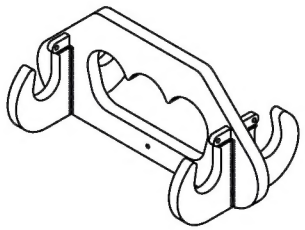
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ±.5°
.X ± .1 SURFACES = 125

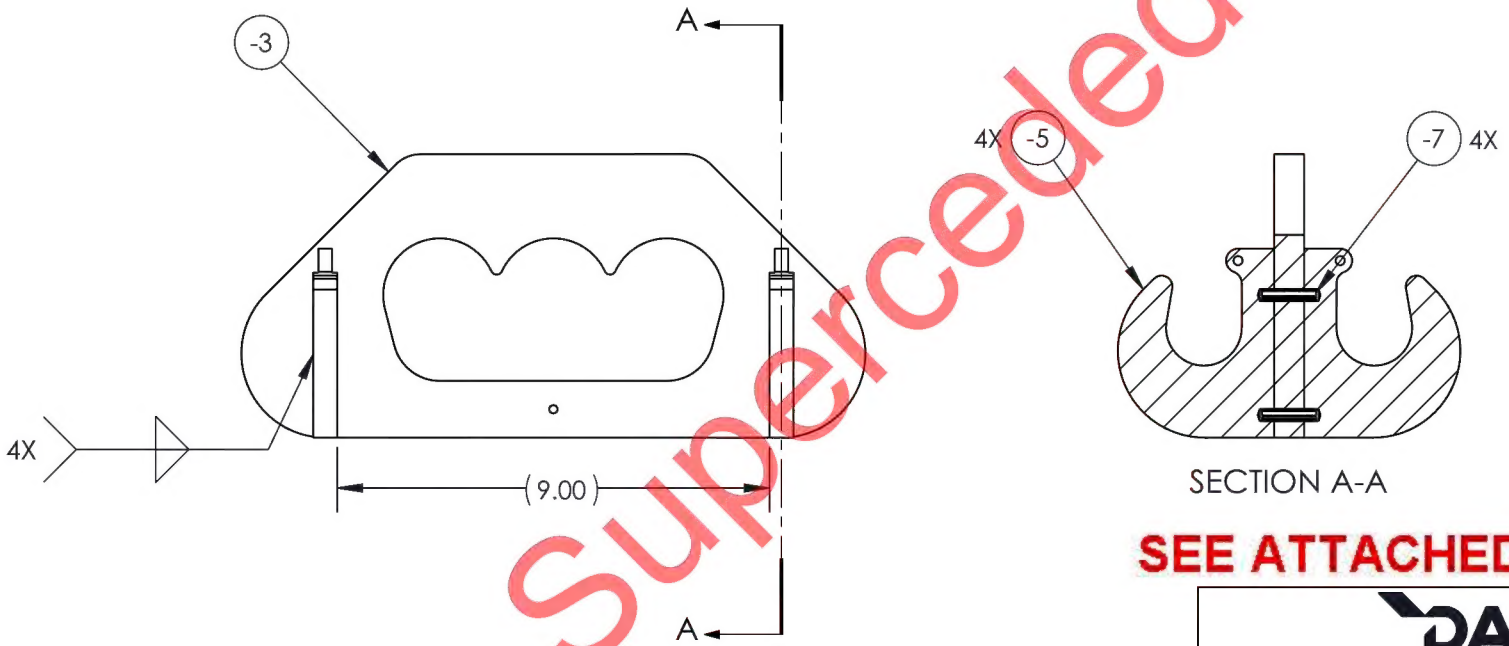
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

USED ON MODEL: EC145

SCALE 1:6 DATE 8/5/2010 SHEET 1 OF 4

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED





SECTION A-A

SEE ATTACHED DEVIATION

-1

WELDMENT

DART AEROSPACE

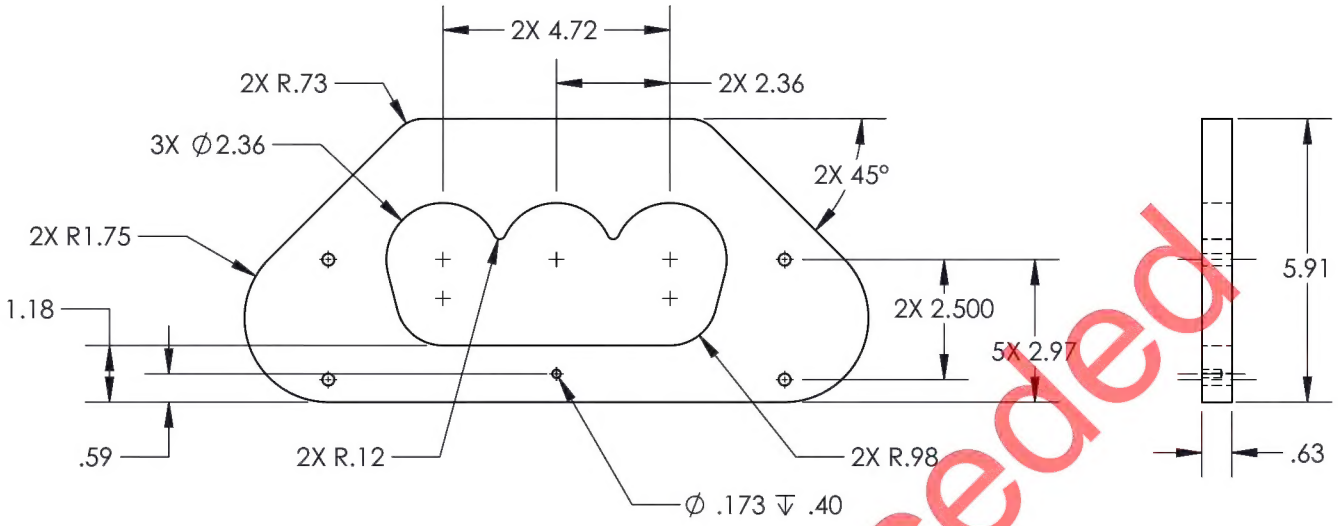
TITLE	MAIN ROTORHEAD REMOVAL/INSTALLATION HOIST
DWG NO.	RBE117-W3-1
REV	1
MAT'L	
HEAT TREAT	
FINISH	POWDER COAT YELLOW
SPEC	FED #13538
DRAWN BY:	CLOUGH
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	1:4
DATE	8/5/2010
SHEET	2 OF 4

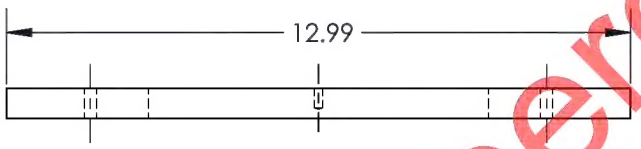
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .03 ANGLES ±1°
.X ± .1 SURFACES = 125

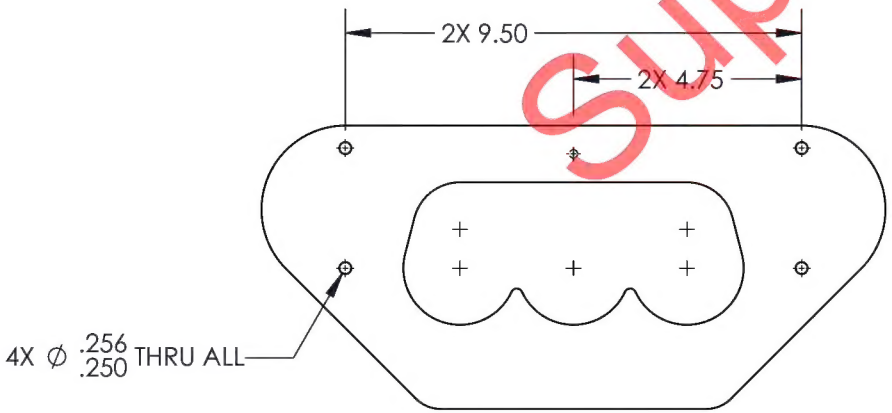
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

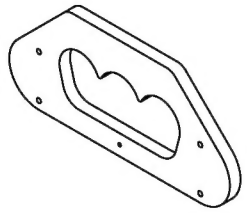
USED ON MODEL
EC145

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED









SEE ATTACHED DEVIATION

-3

FRAME

DART AEROSPACE

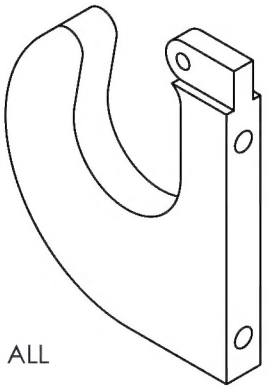
TITLE	MAIN ROTORHEAD REMOVAL/INSTALLATION HOIST
DWG NO.	RBE117-W3-3
REV	1
MAT'L	1018/1020 CR
HEAT TREAT	
FINISH	SEE -1 WELDMENT
SPEC	
DRAWN BY:	CLOUGH
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	1:4
DATE	8/5/2010
SHEET	3 OF 4

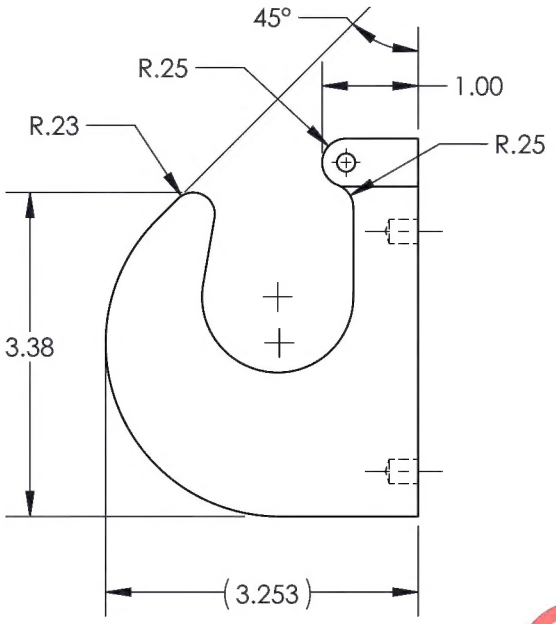
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .03 ANGLES ±1°
.X ± .1 SURFACES = 125

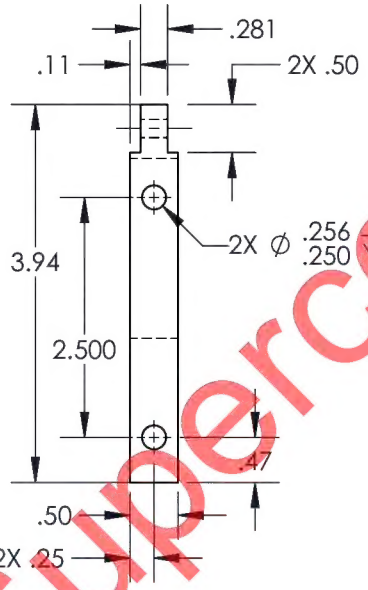
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

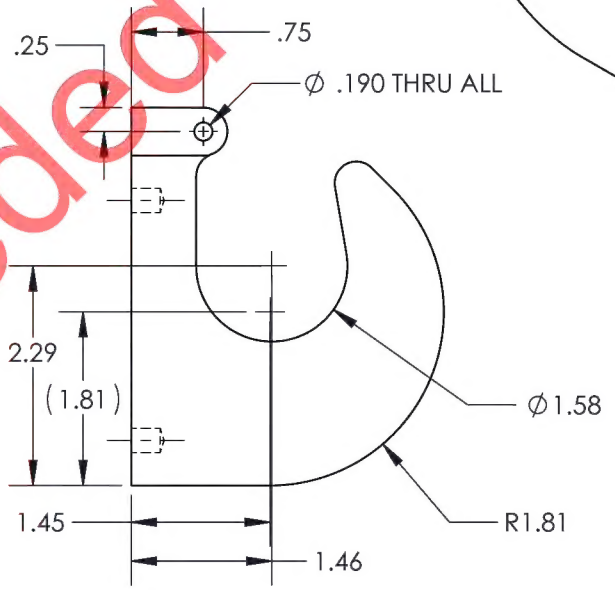
USED ON MODEL
EC145

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED









Superceded

SEE ATTACHED DEVIATION

-5

HOOK

DART AEROSPACE

TITLE	MAIN ROTORHEAD REMOVAL/INSTALLATION HOIST
DWG NO.	RBE117-W3-5
REV	1
MAT'L	1018/1020 CR
HEAT TREAT	
FINISH	SEE -1 WELDMENT
SPEC	
DRAWN BY:	CLOUGH
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	1:2
DATE	8/5/2010
SHEET	4 OF 4

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .010 FRACTIONS ± 1/8
.XX ± .03 ANGLES ±1°
.X ± .1 SURFACES = 125

1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

USED ON MODEL
EC145

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only ☐

Job: _____

Part No. RBE117-W3 REV. 1

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐

DEPARTMENT/PROCESS

Skid-tube	☐	Cross tube	☐	Eng. (Non-AW)	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Water Jet	☐
Large Fab	☐	Finishing	☐	Rec/Store/Packaging	☐	Supplier	☐
						Quality	☐

Date :

Sequence #:

QTY Affected :

MRB (QSI042)

MLee

Oct 9, 2018

Description Work Order Deviation

CL-102-KA-9 Lanyard and CL-4-F Ferrule can be replaced with McMaster Carr 30345T532 Lanyard and 90905A673 Split Ring.

Disposition

This deviation is acceptable.

The fit, form and function of the part will be as originally intended.

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Superceded

Root Cause

Operator	
Manufacturing Process	X
Equip/Tooling	
Handling/Presservation	
Material	X
Product Improvement	
Process Improvement	
Human Factors	

FAULT CATEGORY

☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance
☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish
☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread
☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	

Other/Details: